

Date: Wednesday, 12/11/2008 1:38:05 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COMFORT SEAT- FRAME
Job Number : 43358	
Estimate Number : 13369	
P.O. Number :	Part Number : D37521
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D3752
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : THERMOFORMING	Drawing Revision : C
Previous Run : 43357	Material :
Written By :	Due Date : 08/12/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.11.12</u>	
Comment : Est. REV: A New Issue 08.06.03 DL verified by:DD	
Est Rev. B Dwg. Update 08/07/22 DL	
Est. Rev. C Dwg. Update Shorter length 08/10/28 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING		
Set up machine program D3752-1		
Set up clamping frame as per folio		
2.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
Comment: Qty.: 10.6670 sf(s)/Unit Total : 10.6670 sf(s)		
GE PLASTICS LEXAN SHEET		
Batch # <u>M105330</u>		
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING		
1) Cut Blanks		
4.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE		
Thermoform as per Dwg. D3752 and Folio		
Dwg. Rev. <u>C</u>		
Folio Rev. <u>C</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 10 PAR #: 17 Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:38:05 PM
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Process Sheet

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Drawing Name: COMFORT SEAT - FRAME

Job Number: 43358

Part Number: D37521

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



JB 08/11/14 (X1)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

JB 08/11/17 (X1)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances.

JB 08/11/17 (X1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/17 (X1)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 263

JS 08/11/18 (X1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/18 (X1)

Job Completion



mf 08-11-18

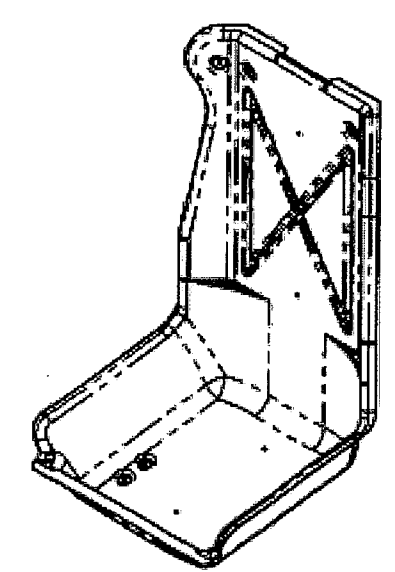
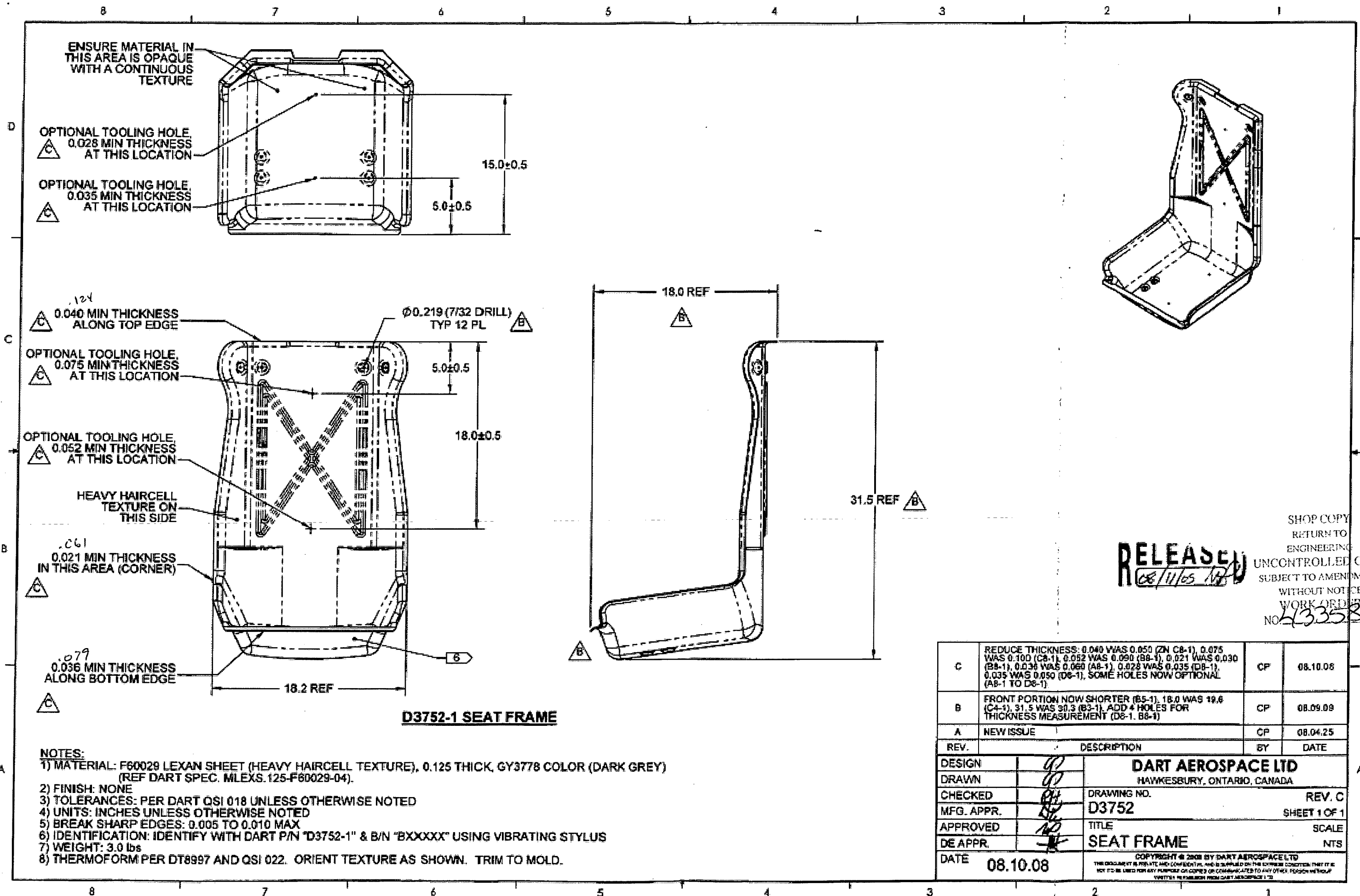
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
08/11/08

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43358

- NOTES:
- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC. MLEXS.125-F60029-04).
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
 - 7) WEIGHT: 3.0 lbs
 - 8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD.

C	REDUCE THICKNESS: 0.040 WAS 0.050 (ZIN C8-1), 0.075 WAS 0.100 (C8-1), 0.052 WAS 0.090 (B8-1), 0.021 WAS 0.030 (B8-1), 0.036 WAS 0.060 (A8-1), 0.028 WAS 0.035 (D8-1), 0.035 WAS 0.050 (D8-1), SOME HOLES NOW OPTIONAL (A8-1 TO D8-1).	CP	08.10.08
B	FRONT PORTION NOW SHORTER (B5-1), 18.0 WAS 19.6 (C4-1), 31.5 WAS 30.3 (B3-1), ADD 4 HOLES FOR THICKNESS MEASUREMENT (D8-1, B8-1)	CP	08.09.08
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D3752	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SEAT FRAME	NTS
DATE	08.10.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DART AEROSPACE LTD		WORK ORDER: 43358
Description: Seat Frame		Part Number: D3752-1
Inspection Dwg: D3752	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	✓
Free of visual flaws (bumps, cracks, voids, etc.)	✓

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____ Rev. __ and record below

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension			Inspection	
0.028"	MIN	.049	✓			
0.035"	MIN	.053	✓			
0.040"	MIN	.115	✓			
0.075"	MIN	.152	✓			
0.052"	MIN	.076	✓			
0.021"	MIN	.061	✓			
0.036"	MIN	.079	✓			

Measured by: BP
Date: 08/11/17

Audited by: S
Date: 08/11/17

Prototype Approval: a/n
Date: 08/11/17

Rev	Date	Change	Revised by	Approved
		New Issue		